

Work Order ID 73170

Friday, August 26, 2011 7:15:28 AM



Page 1

Item ID: D3642-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/08/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3642

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

2029.050

1-Cut as per Dwg D3642 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B11-8-31

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-31

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sub 9/01

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73170

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Page 2

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Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 6 11-09-01

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 6 11-09-01

150

Identify as per dwg & Stock Location: ST 244

0.00



Packaging

Memo

0.00

Packaging

10x 11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73170

Friday, August 26, 2011 7:15:28 AM



Page 3

Item ID: D3642-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/01
MF
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:15:25 AM

Page 1

Work Order ID: 73170

Parent Item: D3642-1

Parent Item Name: Doubler





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	95.9000	0.1664 	1.050947	1.7 B11-8-31		

Location

Loc Qty

Loc Code

MAT22

95.9

117684

95.9

117684

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73170
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.129	✓		V HB2	
Ø0.098	+0.004/-0.001	.100	✗		V	
0.35	+/-0.030	.352	✗		V	
1.25	+/-0.030	1.247	✗		V	
1.700	+/-0.010	1.701	✓		V	
2.15	+/-0.030	2.149	✓		V	
3.05	+/-0.030	3.052	✓		V	
3.95	+/-0.030	3.955	✓		V	
4.078	+/-0.010	4.079	✓		V	
4.85	+/-0.030	4.852	✓		V	
5.20	+/-0.030	5.206	✓		V	
0.343	+/-0.010	.350	✗		V	
0.40	+/-0.030	.406	✓		V	
1.30	+/-0.030	1.310	✗		V	
3.35	+/-0.030	3.348	✓		V	
3.47	+/-0.030	3.474	✓		V	
3.79	+/-0.030	3.79	✗		V	
3.959	+/-0.010	3.963	✓		V	
4.08	+/-0.030	4.084	✓		V	
4.60	+/-0.030	4.602	✓		V	
1.537	+/-0.010	1.536	✓		V	
3.28	+/-0.030	3.280	✓		V	
3.80	+/-0.030	3.80	✓		V	
3.915	+/-0.010	3.917	✓		V	
0.450	+/-0.010	.448	✓		V	
4.066	+/-0.010	4.070	✓		V	
4.20	+/-0.030	4.204	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-8-31	Date: 11/09/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	



11 SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 73670

RELEASE
JUL 11 1964

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	UG		
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	SC	D3642	SHEET 1 OF 1
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOUBLER	4.5
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	